

Work Order ID 156431

156431

Page 1

Monday, January 30, 2017 11:14:16 AM

Item ID: D407-797-111 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: 407 Quick Release Mounting Provisions - Fits LH or RH
 Start Date: 1/11/2017 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 1/27/2017 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JAN 30 2017 Tooling: Date: Run Start *NR1*
 QC: DAS 21 9-89 Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-797-1	D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD407-797-111 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

MAR 06 2017

DAS 6 9-89

DAS 21 9-89

17-03-06

2

DAS 27 9-89

MAR 07 2017

2

DAS 6 9-89

MAR 06 2017

DAS 28 9-89

2

DAS 27 9-89

MAR 07 2017

Work Order ID 156431

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Item ID: D407-797-111**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** 407 Quick Release Mounting Provisions - Fits LH or RH**Start Date:** 1/11/2017 **Start Qty:** 2.00 ***2*****Cust Item ID:****Required Date:** 1/27/2017 **Req'd Qty:** 2.00 ***2*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D407-797-111 Location: FG034								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.03							
Quality Control									

X2

DAS
27
9-89

MAR 07 2017

DAS
21
9-89

MAR 07 2017

DAS
21
9-89

MAR 07 2017

Picklist Print

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Page 1

Work Order ID: 156431

156431

Parent Item: D407-797-111

D407-797-111

Parent Item Name: 407 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 1/11/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.02.09 new issue DD verf:JLM
11.09.12 @ chg 002 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4271-011

Manufactured

No

110

Each

7.0000

1

2

D4271-011

Beam Assembly, Fwd

★★

MAR 06 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST452

7

145658

2

145659

2

151055

1

151733

1

153100

1

D4271-013

Manufactured

No

110

Each

6.0000

1

2

D4271-013

Beam Assembly, Aft

★★

MAR 06 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST453

6

145559

2

146767

1

151030

1

151704

1

153087

1

D4292-1

Manufactured

No

110

Each

14.0000

2

4

D4292-1

Fitting

★★

MAR 06 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

st533

14

146797

4

151725

10

DAS
28
9-89

DAS
6
9-89

DAS
28
9-89

DAS
6
9-89

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 2

Work Order ID: 156431

156431

Parent Item: D407-797-111

D407-797-111

Parent Item Name: 407 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 1/11/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

D4294-1

Manufactured No

110 Each

10.0000 2 4

D4294-1

Fitting

**

MAR 06 2017 6 28 9-89

Location

Loc Qty

Loc Code

st533

10

144612

3

151724

7

D4314-1

Manufactured No

110 Each

25.0000 4 8

D4314-1

Shim

**

MAR 06 2017 6 28 9-89

Location

Loc Qty

Loc Code

ST091

25

123102

9

151130

8

151796

4

153532

4

D4314-3

Manufactured No

110 Each

37.0000 4 8

D4314-3

Shim

**

MAR 06 2017 6 28 9-89

Location

Loc Qty

Loc Code

ST091

37

119651

7

123115

20

154329

10

AN6-17A

Purchased No

110 Each

16.0000 2 4

AN6-17A

Bolt

**

MAR 06 2017 6 28 9-89

Location

Loc Qty

Loc Code

ST334

16

m130466

6

m135671

10

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Work Order ID: 156431

156431

Parent Item: D407-797-111

D407-797-111

Parent Item Name: 407 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 1/11/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

AN6-20A Purchased No

110 Each 50.0000 2 4

AN6-20A

BOLT

**

DAS 6 28 9-89

MAR 06 2017

DAS 27 9-89

Location

Loc Qty

Loc Code

over005

35

M134943

20

M136148

15

ST334

15

M133932

15

4

NAS1149D0663J

Purchased No

110 Each 793.0000 8 16

NAS1149D0663.J

Washer

**

DAS 28 9-89

MAR 06 2017

DAS 27 9-89

Location

Loc Qty

Loc Code

ST260a

600

M136192

600

ST263

193

M135948

193

16

MS21042L6

Purchased No

110 Each 273.0000 4 8

MS21042L6

Nut

**

DAS 28 9-89

MAR 06 2017

DAS 27 9-89

Location

Loc Qty

Loc Code

OVER007

150

m136295

50

m136450

50

m136579

50

ST303

123

m135864

100

m135979

23

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											

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Work Order ID: 156431

156431

Parent Item: D407-797-111

D407-797-111

Parent Item Name: 407 Quick Release Mounting Provisions - Fits LH or RH

Start Date: 1/11/2017

Required Date: 1/27/2017

Start Qty: 2.00

Required Qty: 2.00

MS27151-19

Purchased

No

110

Each

49.0000

4 8

MS27151-19

NUT

**

MAR 06 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST275

49

m132285

18

m132399

31

MS24694-10

MS24694-S10

Purchased

No

110

Each

0.0000

4 8

MS24694-10

SCREWS

D4713-1

Manufactured

No

110

Each

42.0000

1 2

D4713-1

Spacer

**

MAR 06 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST121

42

146084

42

MS3367-5-0

Purchased

No

110

Each

86.0000

1 2

MS3367-5-0

Tie Wrap

**

MAR 06 2017

DAS
27
9-89

Location

Loc Qty

Loc Code

ST272

86

123164

86

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

REFERENCE ONLY**5.0 PARTS LIST**

Qty -011	Qty -012	Qty -013	Qty -014	Qty -111	Part Number	Description
X					D407-797-011	QUICK RELEASE HELI-UTILITY-BASKET
	X				D407-797-012	QUICK RELEASE HELI-UTILITY-BASKET
		X			D407-797-013	QUICK RELEASE HELI-UTILITY-BASKET
			X		D407-797-014	QUICK RELEASE HELI-UTILITY-BASKET
1	1	1	1	X	D407-797-111	QUICK RELEASE BASKET MOUNTING KIT
1					D4272-011	BASKET ASSY, HEAVY DUTY LID, LH
	1				D4272-012	BASKET ASSY, HEAVY DUTY LID, RH
		1			D4272-013	BASKET ASSY, LIGHT WEIGHT LID, LH
			1		D4272-014	BASKET ASSY, LIGHT WEIGHT LID, RH
				1	D4271-011	BEAM ASSY, FWD
				1	D4271-013	BEAM ASSY, AFT
				2	D4292-1	FITTING
				2	D4294-1	FITTING
				4	D4314-1	SHIM
				4	D4314-3	SHIM
				1	D4713-1	SPACER
				2	AN6-17A	BOLT
				2	AN6-20A	BOLT
				8	NAS1149D0663J	WASHER (OR AN960JD616)
				4	MS21042L6	NUT (OR MS21042-6)
				4	MS27151-19	NUT
				4	MS24694-10	SCREW
				1	MS3367-5-0	TIE WRAP